

Date: Friday, 12/01/2007 7:13:27 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 3" OUTER TUBE
Job Number : 30249	
Estimate Number : 10053	
P.O. Number : N/A	Part Number : D26001160
This Issue : 12/01/2007 S.O. No. : N/A	Drawing Number : D2600 REV D1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : D1
Previous Run : 24508	Material : N/A
Written By : [Signature]	Due Date : 26/01/2007 Qty: 160 Um: Each
Checked & Approved By : [Signature]	
Comment : Est. D: 02.09.05 Added DSK 066 KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 2858

- a) Extrude as per Dwg D2600
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 40 ksi
- e) Minimum elongation = 8%
- f) Order at 160" long
- g) Bon L Canada Inc. tool # 897121
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

C 20710112

160

2.0	D26001160P	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 160.0000 Each(s)
Extrusion Round 3" 206

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure material certification is attached

20710126 *178*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/02/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/01/2007 7:13:27 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" OUTER TUBE

Job Number: 30249

Part Number: D26001160

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimension per Dwg D2600

Check Pull test per Dwg D2600 for compliance page attached

Check hardness with Webster tester

07-02-06 *178*

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LG/Bob hall*

DP/1R

7-2-11

178

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/12

Job Completion



W 07-02-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS + DIE NUMBERS <i>+ GP</i>	

RELEASED
98 08 25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

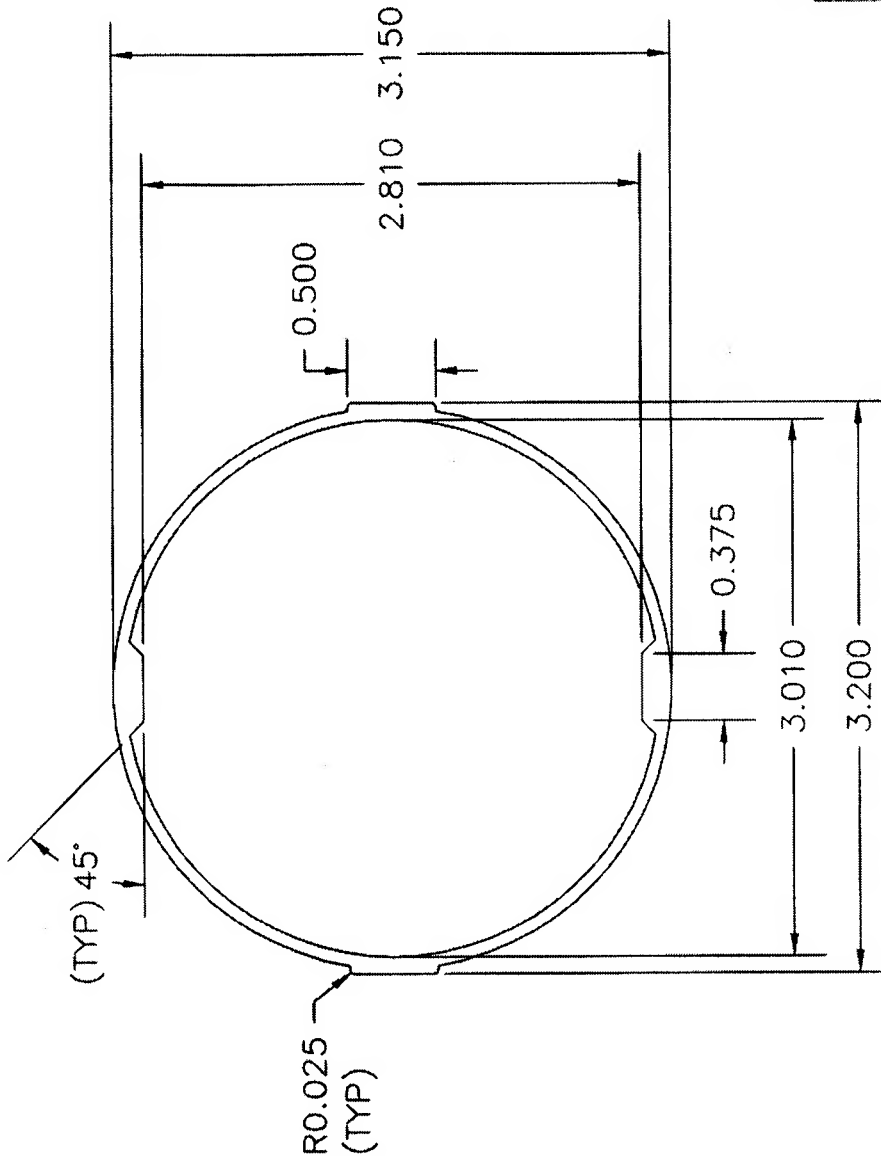
A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.



DESIGN <i>DP</i>	DRAWN BY <i>DP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DP</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-1

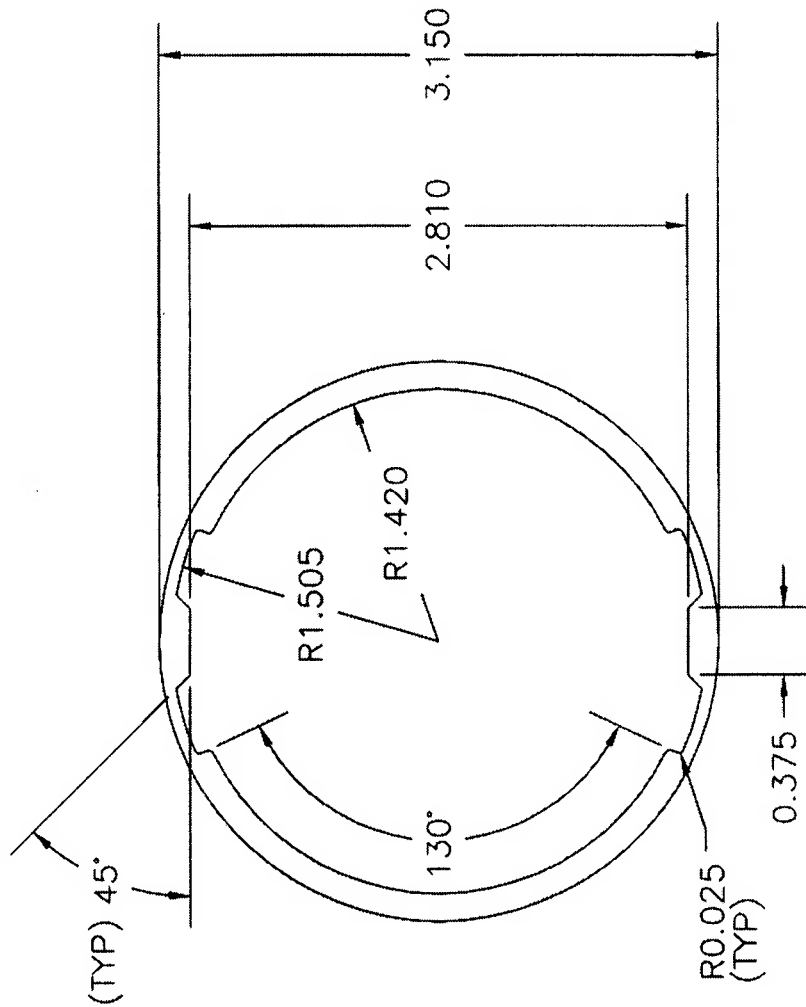
MANUFACTURED WITH CARADON INDALOX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

WLO 3024



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

RELEASED
98.8.25 DS



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

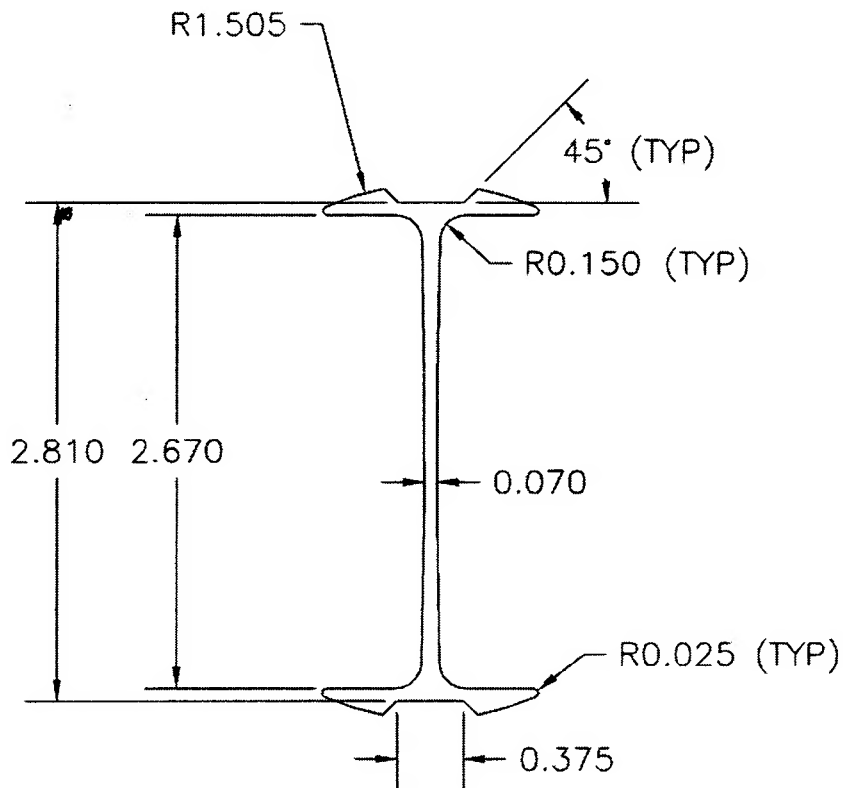
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (Eg. D2600-3-120 IS 120" LONG)





DESIGN	<i>ME</i>	DRAWN BY	<i>ME</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>KE</i>	APPROVED	<i>KE</i>	REV. D
DATE	98.08.20	TITLE	D2600	SHEET 4 OF 5
		EXTRUSION		SCALE 1:1

RELEASED
98 8 25 BS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871

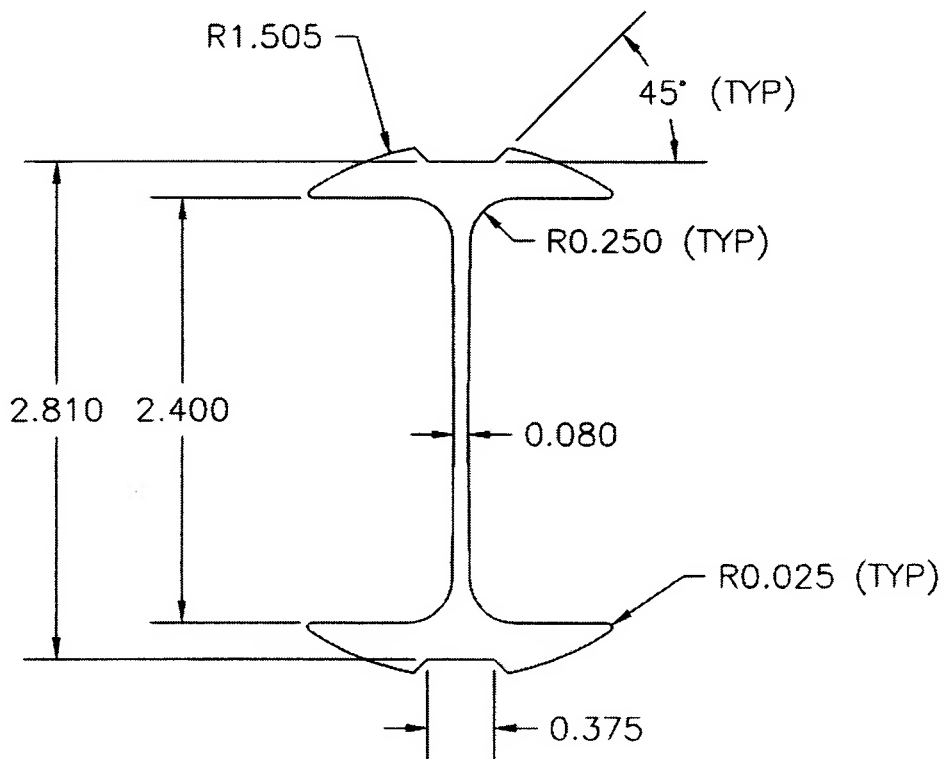


PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)



DESIGN	<i>PM</i>	DRAWN BY	<i>PM</i>	DART AEROSPACE LTD HAMKESBURT, ONTARIO, CANADA	
CHECKED	<i>LE</i>	APPROVED	<i>JS</i>	DRAWING NO.	REV. 0
DATE	98.08.20			TITLE	SHEET 5 OF 5
				EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872

PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES

(EG. D2600-7-125 IS 125" LONG)



BON L CANADA INC.

THE WILLIAM L. BONNELL COMPANY, INC.
BON L MANUFACTURING COMPANY
SUBSIDIARIES OF TREDEGAR CORPORATION
FILIALES DE LA CORPORATION TREDEGAR



BON L CANADA INC
500 EDWARD AVENUE
RICHMOND HIL ON

L4C 4Y9

INVOICING COMPANY AND LOCATION
BUREAU DE FACTURATION

SHIPPING MANIFEST BORDEREAU D'EXPÉDITION

MANIFEST DATE/DATE D'EXPÉDITION

01-23-07

MANIFEST NUMBER/N° D'EXPÉDITION

565536

SALES ORDER NUMBER/N° DE COMM.

54641

SALES REP
REP. DES VENTES

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE.
RÉFÉREZ-VOUS À CES
NUMÉROS POUR TOUTE
CORRESPONDANCE.

CREDIT REP
REP. DU CRÉDIT
HAMBROOK, PAU
905-508-3250

FIELD SALES REP
REP. RÉGIONAL DES VENTES
Kutter A
450-435-6551

CUST SERVICE REP
REP. SERVICE CLIENTÈLE
Burton D
905-427-2227

ACCT# 00046024

SHIP TO/EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY
K6A 1K7

ON

CN

SOLD TO/ VENDU À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY
K6A 1K7

ON

CN

O/P

PHONE 613-632-3336

PHONE 613-632-3336

LOC/USINE

TRAILER NO./N° DE REMORQUE

SALESMAN/VENDEUR

RIH

57360

59358

CUSTOMER ID/N° DU CLIENT

ORDER DATE
DATE DE LA COMMANDE

CUST. P.O. NO./N° DE COMM. DU CLIENT

JOB/PROJET

46024

01/12/07

2858

BILL OF LADING NUMBER/N° DE CONNAISSANCEMENT

00332049

ITEM NO. D'ITEM	ORDER QUANTITY QTE COMMANDEE	UNIT UNITE	PREVIOUS SHIPPED QTY QTE DEJA EXPEDIEE	MFG. PART NUMBER N° DE PIECE DU FOURNISSEUR CUSTOMER PART NUMBER NUMERO DE PIECE DU CLIENT	ALLOY & TEMPER ALLIAGE & TREMP LENGTH LONGUEUR CUTTING TOLERANCE TOLERANCE DE COUPE	FINISH DESCRIPTION DESC. DE LA FINITION FABRICATION DESCRIPTION TYPE DE FABRICATION SHIPPING TOLERANCE TOLERANCE D'EXPÉDITION	THIS SHIPMENT/CETTE EXPÉDITION			UNIT UNITE	QUANTITY D. QUANTITE PRE
							NO. PKGS N° DE PAQUETS	GROSS WT. POIDS BRUT	NET WT. POIDS NET		
01	160	KG M PC	0 0 0	DAA-897121-1 D2600-1-160	6061 /T6 160" +5/16 " -0 "	MILL CERTIFICATE OF COMP (+010-010,0176-0144)	5	1132	1069	KG M PC	
				DETAIL; LOT/TICKET		54641010 / 161854 54641010 / 161856 54641010 / 161857 54641010 / 161858 54641010 / 161968	1 1 1 1 1	248 248 248 144 244	234 235 234 132 234		39 P 39 P 39 P 22 P 39 P
							5	1132	1069	KG M PC	

FORM NO. B1065 REV. C

NO RETURN MATERIALS WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION

AUCUN RETOUR DE MATÉRIEL NE SERA ACCEPTÉ POUR CRÉDIT SANS AUTORISATION

CUSTOMER
CLIENT

1

TOTALS/TOTAUX

**BON L CANADA INC**

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

CERTIFICATE OF COMPLIANCE

Card Date	Cert No	Sales Order	Page
01/23/07	153933	54641	1
Cust PO	P/I No	Lot	Date
2858	00332049	54641010	1/23/07
Sold To	46024	Ship To	46024
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	
Item No	Part No	Item Description	Cust Part
1.000	DAA-897121-1	160" Mill 6061 T6	D2600-1-160
Gross Weight	1132 KGS		
Net Qty	1,069 KG	178 PC	723 M 5 PKG
Specification	AMS-QQ-A-200/8 & ASTM B221-00		

Mechanical Tests:											
Test No.	Tensile		Yield		%Elongation		Conductivity		Bend/Drift HREW		
	MPA	KSI	MPA	KSI							
1	322.1	46.7	286.2	41.5	10.9		.0				93
2	322.1	46.7	283.5	41.1	10.9		.0				93
Chemical Analysis:											
SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	OTHER
.67	.28	.28	.10	.87	.06	.006	.06	.000	.009	.02	.000 .00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada